

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002814**Date Inspected:** 04-Jun-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai,China**CWI Name:** Luan Zhao Gaug**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Tim McClendon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

The Caltrans QA Inspector's have observed that there are six (6) OBG assembly segments that are at various stages of fabrication. Four (4) segments are being assembled at the south end of the bay and are identified as segments 3AE, 3BE, 4AE, and 4BE. At the far north end of the bay are segments 3BW and 4AW are being assembled. The following specifics apply to each segment observed.

OBG Assembly Segment 3AE- The Caltrans QA Inspector observed that ZPMC has fit-up the FL1 floor beam on the south side and also the FL2 to the bottom plate.

OBG Assembly Segment 3BE- The Caltrans QA Inspector observed that ZPMC is in process of fitting up the longitudinal diaphragm to the D6 bottom plate adjacent to the E7 side plate.

The Caltrans QA Inspector observed that ZPMC has positioned both side plates C5 and E7 adjacent to the bottom plate D6 on OBG Assembly Segment 4AW. ZPMC has fit-up the CJP splice groove that will join side plate C5 to the bottom plate. The CJP fit-up appears to be in compliance with the applicable WPS. ZPMC personnel were observed thermal cutting and grinding the CJP bevel on the E7 side plate that will mate with the D6 bottom plate.

OBG Assembly Segment 3BW- The Caltrans QA Inspector observed that ZPMC has fit-up a floor beam to this

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assembly. This floor beam includes both FL1-1's and also the FL2-1 upper and FL2-2 lower onto the assembly.



### Summary of Conversations:

No relevant conversations spoken on this date.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Pat Lowry, (858) 344-2712, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	McClendon, Timothy	Quality Assurance Inspector
<b>Reviewed By:</b>	Cuellar, Robert	QA Reviewer

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